



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2940-1

Job Sheet 171994



Part No: D2940-1

Job Qty: 6 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/26/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV C IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/23/18	0.00	0.00	Start Up Machining-1		SBL 18/02/26
100	CNC Vertical Machining	6 pcs		2/24/18	0.32	14.29	HAAS1-2		SC 18/02/28
110	QC	6 pcs		2/24/18	0.00	0.00	QC2 Machining-1		SC 18/02/28
120	QC	6 pcs		2/24/18	0.00	0.00	QC8 Machining-1		SC 18-02-01
130	Crosstubes	6 pcs		2/26/18	0.00	0.75	Crosstubes-2		✓ AF MAR 0 1 2018
140	QC	6 pcs		2/26/18	0.00	0.00	QC5		✓ 21
170	Packaging	6 pcs		2/26/18	0.00	0.00	Packaging3-1	46052	MAR 0 2 2018
180	QC21-SA	6 Ea		2/26/18	0.00	0.00	QC21		21 MAR 0 5 2018

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 130 - Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG052

138381

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	3 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK081	3	10	0



Container No: S045463



Part: D2940 - 1

Job No: 171994

Serial No/Batch: S045463

Revision: D2940

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/26/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240	.250	
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490	.500	
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140	.160	
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510	3.522	
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633	1.670	
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493	1.510	
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188	.187	
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140	.160	
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518	2.528	
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040	.047	
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140	.151	
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350	.400	
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240	.250	
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150	.162	
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640		
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260	.261	
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118	4.127	

Plex 2/12/18 7:26 AM dart.leroux.jason

DART AEROSPACE LTD		Work Order: 171994
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.155	.155	.155	.155	.155
AD	3.510	3.530		3.522	3.515	3.521	3.520	3.520
AE	1.633	1.673		1.670	1.670	1.670	1.670	1.670
AF	1.493	1.513		1.510	1.509	1.509	1.509	1.509
AG	0.040	0.060		.048	.053	.050	.053	.045
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.149	.149	.148	.148	.148
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.047	.052	.047	.047	.047
AL	0.010	0.020		.01	.01	.01	.01	.01
AM	0.140	0.160		.151	.157	.157	.157	.157
AN	0.350	0.450		.363	.400	.400	.400	.400
AO	0.240	0.260		.250	.280	.250	.250	.250
AP	0.150	0.170		.157	.155	.155	.155	.155
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.127	4.127	4.127	4.127
AV								
AW								
Accept/Reject								

Measured by: S.C.	Date: 18/02/28
Audited by: B.A.	Date: 18-03-01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order: 171944
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

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HAAS Section								
AA	0.240	0.260		.250				
AB	0.490	0.510		.500				
AC	0.140	0.160		.154				
AD	3.510	3.530		3.520				
AE	1.633	1.673		1.669				
AF	1.493	1.513		1.510				
AG	0.040	0.060		.052				
AH	0.188	0.193		.188				
AI	0.140	0.160		.148				
AJ	2.518	2.538		2.528				
AK	0.040	0.060		.047				
AL	0.010	0.020		.01				
AM	0.140	0.160		.153				
AN	0.350	0.450		.400				
AO	0.240	0.260		.250				
AP	0.150	0.170		.152				
AQ	0.053	0.073		.063				
AR	101.64	105.64		103.64				
AS	0.260	0.267		.261				
AT	0.053	0.073		.063				
AU	4.118	4.138		4.128				
AV								
AW								
Accept/Reject								

Measured by: SC.	Date: 18/02/28
Audited by: D.A.	Date: 18-03-01
Prototype Approval:	Date:

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